

Work Order ID 109668

November-25-13 10:14:33 AM

109668

Page 1

Item ID: D4095-043

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Wearplate Assembly

Stop *NS2*

Start Date: 11/25/13 Start Qty: 12.00

Required Date: 12/09/13 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 13-11-25 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D4095	B
-------	---

100

0.00

100

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg (D4095-3)

Dwg Rev: 3

Prog Rev: 3

2-Deburr if necessary

14 0 Ac
13.11.26

110

0.00

110

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

14 0 Ac
13.11.26

120

0.00

120

QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

DAS
27
9-89

14 _____

Bl/1/26

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Page 2

Item ID: D4095-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate Assembly
 Start Date: 11/25/13 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 12/09/13 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	NC BRAKE Memo 1- bend section C-C first 2- Form on Brake as per Dwg D4095 using Jigs DT 8179 and DT 8155 3- Form Joggles (2) as per Dwg D4095 on brake using Jig DT 8157	0.00 0.00		DAS 30 9-89		14			13/11/26
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo Ensure joggle as per dwg D4095	0.00 0.00		Shp 13/11/27		14			
150 *150* Large Fab Large Fab	Weld per dwg A/R Hardcoat S.S. Batch: <u>11127112</u> Large Fab Memo	0.00 0.00				4			13-11-28 JBC

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Page 3

Item ID: D4095-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate Assembly

Start Date: 11/25/13 Start Qty: 12.00

12

Cust Item ID:

Required Date: 12/09/13 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00 SPB 11/11/28				4			
170 *170* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00 SPB 11/11/28				4			
180 *180* HandFinish Hand Finishing	COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER DWG A/R ROCKGUARD BATCH: <u>125335</u>	0.00 0.00				4	0	0	AS 13-11-28

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RM 13/12/02

Picklist Print

November-25-13 10:14:37 AM

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Work Order ID: 109668

109668

Parent Item: D4095-043

D4095-043

Parent Item Name: Wearplate Assembly

Start Date: 11/25/13

Required Date: 12/09/13

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A new issue DD 10.04.26 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	352.2540	2.275	29			
										**	30	Jm13-11-25	
M304S16GA													
304/316 Sheet .063													

Location

Loc Qty

Loc Code

MAT020

352.2539998

123136

140.2

M126159

26.22

M126915

185.834

269.5

DART AEROSPACE LTD		Work Order: 109668
Description: Wearplate		Part Number: D4095-3
Inspection Dwg: D4095	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

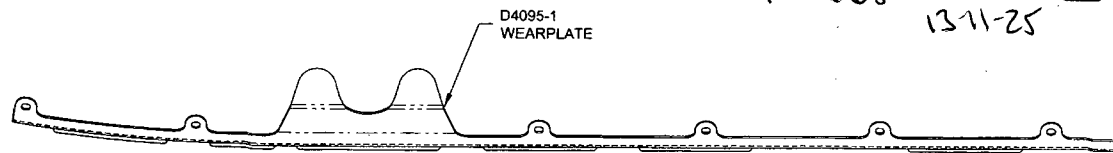
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	0.190"	-		✓	Jkma1
0.300	+/-0.010	0.304"	-		✓	
0.300	+/-0.010	0.302"	-		✓	
2.432	+/-0.010	2.436"	-		✓	
3.227	+/-0.010	3.230"	-		✓	
4.06	+/-0.030	4.06"	-		✓	
2.50	+/-0.030	2.50"	✓		✓	
4.98	+/-0.030	4.98"	-		✓	
8.43	+/-0.030	8.43"	-		✓	Prozwoz
11.50	+/-0.030	11.504"	-		✓	
21.750	+/-0.010	21.750"	-		T	Jkmo6
3.500	+/-0.010	3.500"	-		✓	
12.22	+/-0.030	12.22"	✓		T	
6.000	+/-0.010	6.005"	-		✓	
12.100	+/-0.010	12.100"	-		T	
21.00	+/-0.030	21.00"	-		T	
30.000	+/-0.010	30.00"	-		T	
36.000	+/-0.010	36.000"	-		T	
38.88	+/-0.030	38.88"	-		T	
0.063	+/-0.010	0.058"	-		✓	

Measured by: Jm	Audited by: DAS 27 9-89	Preliminary Approval:
Date: 13-11-25	Date: 13-11-26	Date:

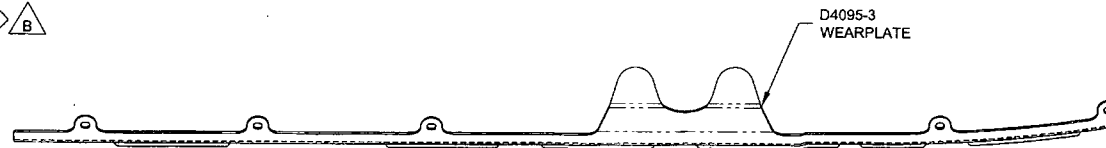
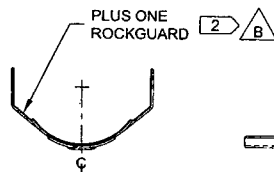
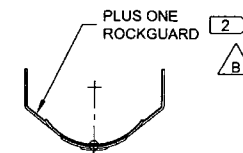
Rev	Date	Change	Revised by	Approved
A	11.02.18	New Issue P/O D4095-043	KJ	
B	11.11.08	Dimensions updated per Dwg Rev B	KJ	

ITEM	QTY	QTY	QTY	QTY	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
1	X							D4095-041	WEARPLATE ASSEMBLY
2		X						D4095-043	WEARPLATE ASSEMBLY
3			X					D4095-045	WEARPLATE ASSEMBLY
4				X				D4095-047	WEARPAD ASSEMBLY
5					X			D4095-049	WEARPAD ASSEMBLY
6						X		D4095-051	WEARPAD ASSEMBLY
7	1							D4095-1	WEARPLATE
8		1						D4095-3	WEARPLATE
9			1					D4095-5	WEARPLATE
10				1				D4095-7	WEARPAD
11					1			D4095-9	WEARPAD
12						1		D4095-11	WEARPAD
13	A/R	A/R	A/R	A/R	A/R	A/R	A/R	4715 (4714)	PLUS ONE ROCKGUARD BLACK (TAN)

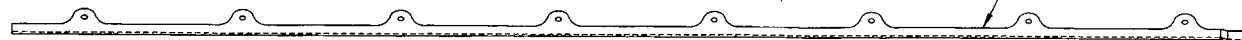
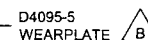
109668 MJS
1311-25



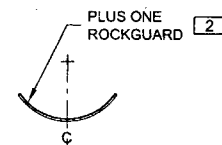
D4095-041 WEARPLATE ASSEMBLY



D4095-043 WEARPLATE ASSEMBLY



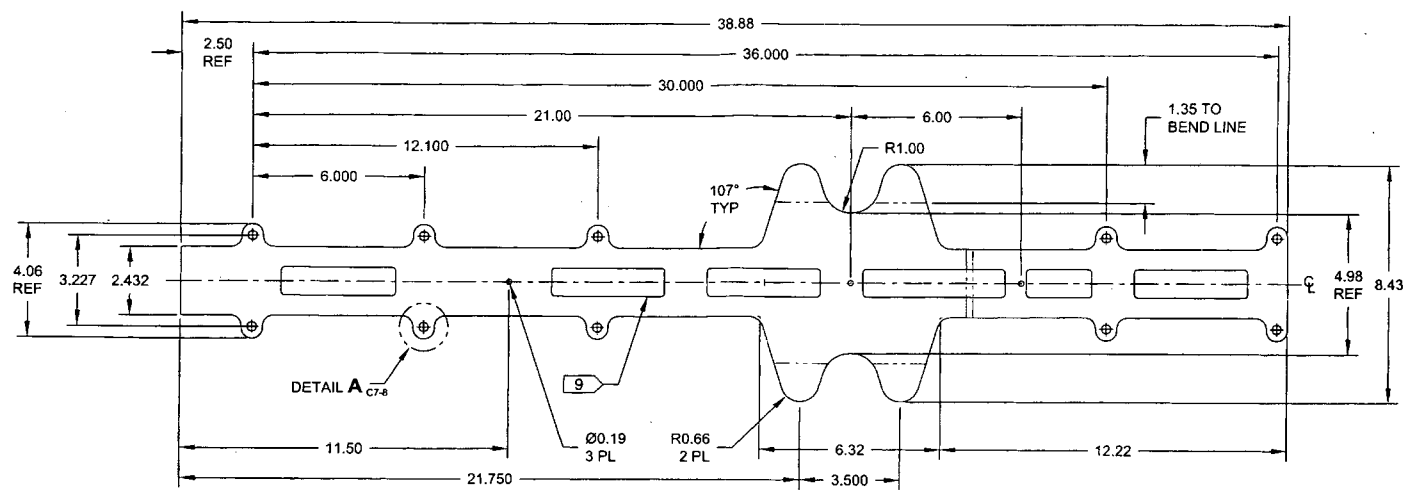
D4095-045 WEARPLATE ASSEMBLY



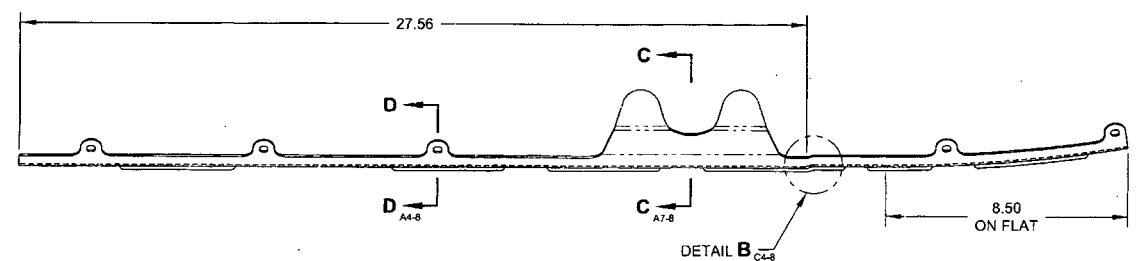
D4095-041/-043/-045/-047/-049/-051 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714 OR 4715, 0.02-0.04 THICK
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-0XX" AND B/N "BXXXXX" USING REMOVABLE TAG PER QSI 044 6.6
- 7) WEIGHT: D4095-041 = 3.08 lbs; D4095-043 = 3.08 lbs; D4095-045 = 2.00 lbs; D4095-047 = 0.48 lbs; D4095-049 = 0.42 lbs; D4095-051 = 0.37 lbs
- 8) PARTS ARE SYMMETRIC ABOUT C

B	REVISED D4095-1/-1F/3/3F: 4715 PLUS ONE ROCKGUARD REPLACES D4095-1/-3; ADDED D4095-5/-7 -9/-11; REVISED HARDCOAT DESIGN; REVISED NOTE 2	XDF	11.10.18
A	NEW ISSUE	MB	10.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	XDF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.10.18		
DART AEROSPACE USA, INC KENT, WA DRAWING NO. D4095 TITLE WEARPLATE REV. B SHEET 1 OF 8 SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



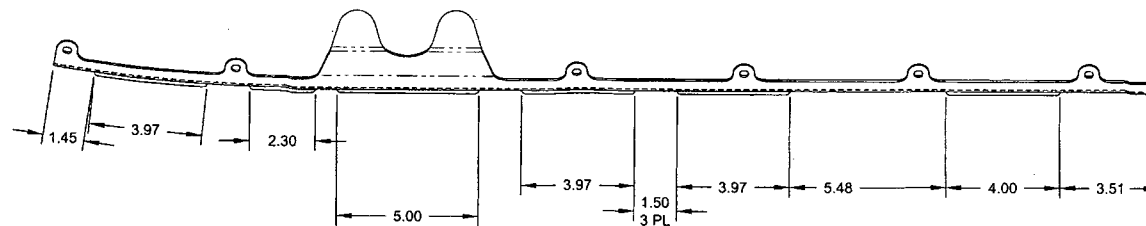
D4095-3F FLAT PATTERN 1



D4095-3 BENDING DETAIL
(MAKE FROM D4095-3F)

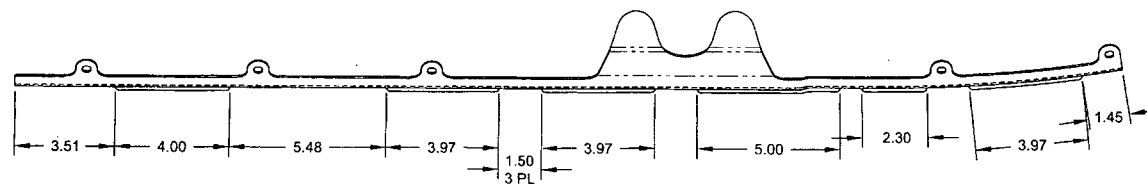
RELEASE
2011-10-31

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DRAWN	XDF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4095	SHEET 4 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE	NTS
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D4095-1 WELDING DETAIL

B

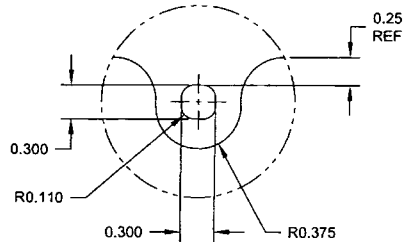


D4095-3 WELDING DETAIL

B

RELEASED
2011-10-31
MP

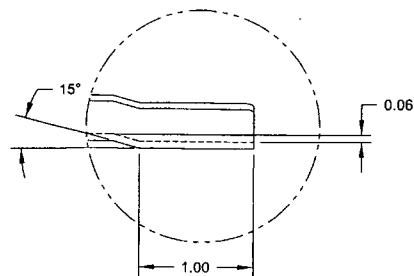
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DRAWN	XDF	KENT, WA	
CHECKED	<i>HP</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>HP</i>	D4095	SHEET 5 OF 8
APPROVED	<i>HP</i>	TITLE	SCALE
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DETAIL A: TAB DETAIL

SCALE 4X

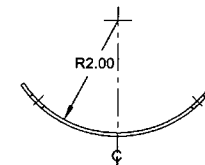
C3-3
C6-4
D3-6
D2-7



DETAIL B: JOGGLE DETAIL

SCALE 4X

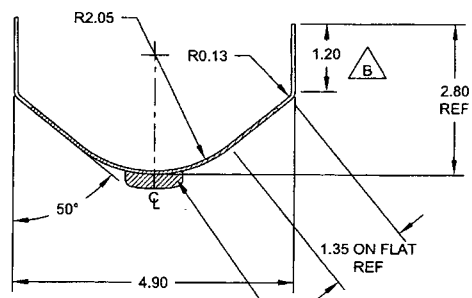
B2-3
B6-3
B3-4
B2-6



SECTION E-E

SCALE 2X

B5-6
B2-7

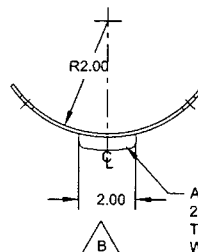


SECTION C-C

SCALE 2X

B5-3
B4-4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

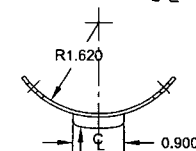


SECTION D-D

SCALE 2X

B4-3
B5-4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK



SECTION F-F

SCALE 2X

B5-7
B7-7

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

RELEASED
2011-10-31
MPO

DESIGN	XDF	DART AEROSPACE USA, INC	
DRAWN		KENT, WA	
CHECKED	10	DRAWING NO.	REV. B
MFG. APPR.	10	D4095	SHEET 8 OF 8
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